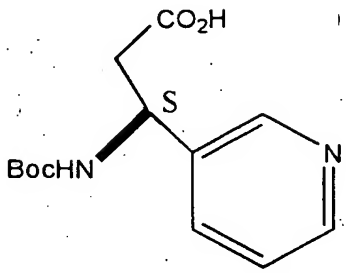
CLAIMS:

1. Form 2 of the compound of formula Va



Va

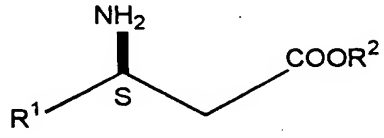
characterized by the following x-ray powder diffraction pattern:

Powder X-Ray Diffraction Results

Angle 2θ	d value Angstrom	Intensity Cps	Intensity %
5.186	17.028	1.67	0.1
5.405	16.338	4.17	0.2
6.069	14.550	163	6.2
6.526	13.532	1350	51.1
7.659	11.534	28.3	1.1
9.111	9.698	22.5	0.9
10.786	8.196	1417	53.6
13.073	6.767	83.3	3.2
15.660	5.654	659	25.0
17.063	5.192	1105	41.8
18.405	4.817	102	3.8
18.843	4.706	212	8.0
19.108	4.641	343	13.0
19.679	4.507	417	15.8
20.755	4.276	36.7	1.4

21.514	4.127	2641	100.0
22.796	3.898	652	24.7
23.944	3.713	101	3.8
24.363	3.650	340	12.9
25.502	3.490	89.2	3.4
25.640	3.471	89.2	3.4
26.265	3.390	172	6.5
26.786	3.326	98.3	3.7
27.770	3.210	1152	43.6
28.722	3.106	164	6.2
29.151	3.061	764	28.9
29.656	3.010	70.8	2.7
30.468	2.9315	58.3	2.2
31.214	2.8631	61.7	2.3
31.868	2.8058	61.7	2.3
32.301	2.7692	95.8	3.6
32.874	2.7222	147	5.6
33.480	2.6743	53.3	2.0
34.081	2.6285	122	4.6
34.626	2.5884	68.3	2.6

2. A process of preparing the compound of formula I

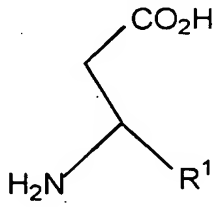


I

wherein

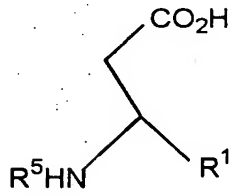
R^1 is aryl, heteroaryl, substituted aryl or substituted heteroaryl and R^2 is hydrogen, alkyl or aralkyl, or acid addition salts thereof,

comprising reacting a compound of formula II, at a pH range of between about 7 and about 11,



II

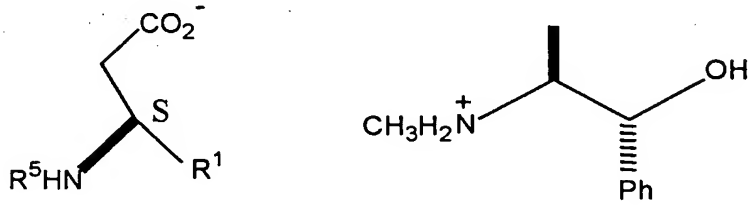
to form a compound of formula III



III

wherein R^5 is N-t-butoxycarbonyl,

reacting a compound of formula III with at least 0.5 equivalents of (1R,2S)-(-)ephedrine, in an alkyl acetate solvent, to form a salt of formula IV

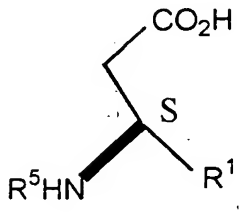


IV

wherein Ph is phenyl,

reacting the salt of formula IV with an inorganic base in water to form a carboxylate salt of the compound of formula V, acidifying the carboxylate salt of the compound of

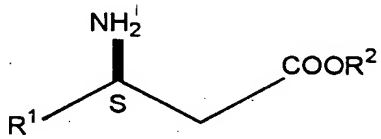
formula V with an acid of pKa less than or equal to three, to a pH of between about 3.5 and about 6.5, to form the compound of formula V



V

reacting the compound of formula V, at a temperature less than about 25°C, to form the compound of formula I.

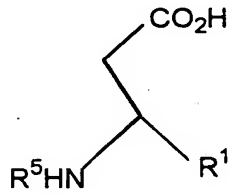
3. A process of preparing a compound of formula I



I

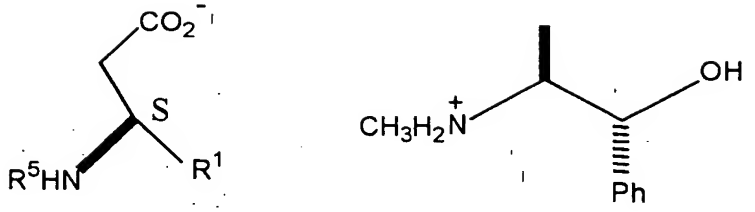
wherein R^1 is aryl, heteroaryl, substituted aryl or substituted heteroaryl and R^2 is hydrogen, alkyl or aralkyl, or acid addition salts thereof,

comprising reacting a compound of formula III



III

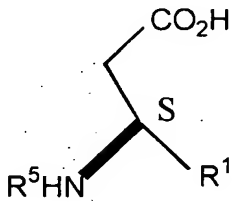
wherein R^5 is N-t-butoxycarbonyl,
with at least 0.5 equivalents of (1R,2S)-(-)ephedrine, in alkyl acetate solvent, to form a salt of formula IV



IV

wherein Ph is phenyl,

reacting the salt of formula IV with an inorganic base, in water, to form a carboxylate salt of the compound of formula V, acidifying the carboxylate salt of the compound of formula V with an acid of pKa less than or equal to three, to a pH of between about 3.5 and about 6.5, to form the compound of formula V



V

reacting the compound of formula V, at a temperature less than about 25°C, to form the compound of formula I.

4. A process of Claim 2, further comprising isolating the compound of formula III by acidifying the compound of formula III with an acid of pKa less than or equal to three, to a pH of between about 3.5 and about 6.5.

5. A process of Claim 2, wherein the alkyl acetate solvent is ethyl acetate.

6. A process of Claim 2, wherein the reaction of formula III with (1R,2S)-(-)ephedrine occurs at a temperature in the range of from about 25° to about 78°C.

7. A process of Claim 2, further comprising acidifying the carboxylate salt of the compound of formula V with an acid of pKa less than or equal to three, to a pH of about 3.8, to form the compound of formula V.

8. A process of Claim 2, wherein the acid of pKa less than or equal to three is selected from the group consisting of monochloroacetic, dichloroacetic, trichloroacetic, hydrochloric, hydrobromic, hydroiodic, perchloric, picric, nitric, sulfuric, phosphoric, methanesulfonic, tosic, trifluoromethanesulfonic, trifluoracetic, potassium bisulfate, sodium bisulfate and citric.

9. A process of Claim 2, further comprising reacting the compound of formula V with an acid of pKa less than or equal to three, other than potassium bisulfate, sodium bisulfate and citric acid.

10. A process of Claim 3, further comprising acidifying the compound of formula III with an acid of pKa less than or equal to three, to a pH of between about 3.5 and about 6.5.

11. A process of Claim 3, wherein the alkyl acetate solvent is ethyl acetate.

12. A process of Claim 3, wherein the reaction of formula III with (1R,2S)-(-)ephedrine occurs at a temperature from about 25° to about 78°C.

13. A process of Claim 3, further comprising acidifying the carboxylate salt of the compound of formula V with an acid of pKa less than or equal to three, to a pH of about 3.8, to form the compound of formula V.

14. A process of Claim 3, wherein the acid of pKa less than or equal to three is selected from the group consisting of monochloroacetic, dichloroacetic, trichloroacetic, hydrochloric, hydrobromic, hydroiodic, perchloric, picric, nitric, sulfuric, phosphoric, methanesulfonic, tosic, trifluoromethanesulfonic, trifluoracetic, potassium bisulfate, sodium bisulfate and citric.

15. A process of Claim 3, further comprising reacting the compound of formula V with an acid of pKa less than or equal to three, other than potassium bisulfate, sodium bisulfate and citric acid.

16. A process of Claim 2, wherein R^1 is 2-pyridyl, 3-pyridyl, 4-pyridyl, 6-methylpyridyl, 5-bromopyridyl, 6-chloropyridyl or 5,6-dichloropyridyl.

17. A process of Claim 3, wherein R^1 is 2-pyridyl, 3-pyridyl, 4-pyridyl, 6-methylpyridyl, 5-bromopyridyl, 6-chloropyridyl or 5,6-dichloropyridyl.

18. A process of Claim 2, wherein R^2 is alkyl.

19. A process of Claim 3, wherein R^2 is alkyl.

20. A process of Claim 2, wherein R^1 is 3-pyridyl.

21. A process of Claim 3, wherein R^1 is 3-pyridyl.

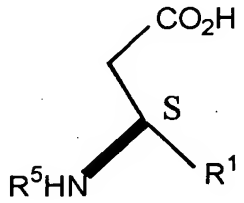
22. A process of Claim 2, wherein R^1 is 3-pyridyl and R^2 is methyl.

23. A process of Claim 3, wherein R^1 is 3-pyridyl and R^2 is methyl.

24. A process of Claim 2, wherein the acid addition salt of formula I is hydrochloric.

25. A process of Claim 3, wherein the acid addition salt of formula I is hydrochloric.

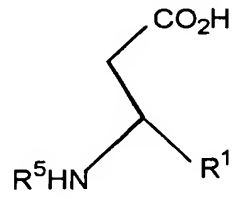
26. A process for preparing a compound of formula V



V

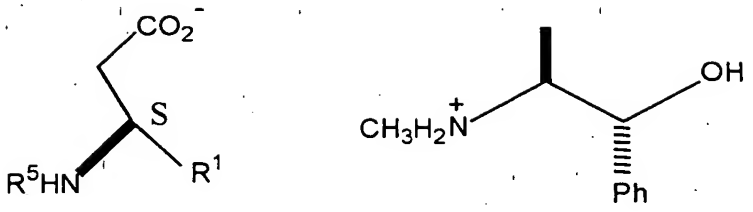
wherein R^1 is aryl, heteroaryl, substituted aryl or substituted heteroaryl and R^5 is N-t-butoxycarbonyl

comprising reacting a compound of formula III



III

with at least 0.5 equivalents of (1R,2S)-(-)ephedrine, in alkyl acetate solvent, to form a salt of formula IV



IV

wherein Ph is phenyl,

reacting the salt of formula IV with an inorganic base, in water, to form a carboxylate salt of the compound of formula V, acidifying the carboxylate salt of the compound of formula V with an acid of pKa less than or equal to three, to a pH of between about 3.5 and about 6.5.